

Harvey

Work Order ID 72699

Monday, August 08, 2011 2:40:53 PM



PRELIMINARY ISSUE

Page 1

Item ID: D4421-7 Accept Setup Start
Revision ID: Stop
Item Name: Lower Curve
Start Date: 8/12/2011 Start Qty: 2.00 Cust Item ID:
Required Date: 8/12/2011 Req'd Qty: 2.00 Customer:
Reference:

Approvals: Process Plan: Date: 8-08-11 Tooling: Date: Run Start
QC: Date: SPC (Y/N): Date: Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4421	PAZ 11.08.23								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
304 .050	Dwg Rev: PAZ								
	Prog Rev: QM2								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B11-8-8

(3)

B11-8-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72699

Monday, August 08, 2011 2:40:53 PM



Page 2

Item ID: D4421-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Lower Curve

Start Date: 8/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspector to PA1

Day only

0.00

Suloblog

(43)

QC

Memo

Quality Control

130

Form as per dwg

0.00

0.00

Brake NC

Memo

Brake NC

(3)

B 11-08-16

140

QC5- Inspect part completeness to step on W/O

0.00 - inspector to

PA1 DWS

only

0.00

Suloblog

(43)

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 72699



Monday, August 08, 2011 2:40:53 PM



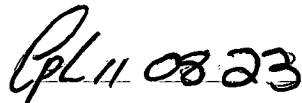



Page 3

Item ID: D4421-7 Accept  Setup Start 
Revision ID: Stop 
Item Name: Lower Curve
Start Date: 8/12/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 8/12/2011 Req'd Qty: 2.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging	Identify as per dwg & Stock Location: PRELIM AREA	0.00							
Packaging	Memo	0.00							
160  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

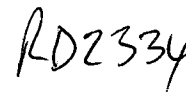
POSITIVE RECALL

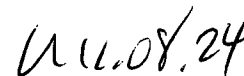
EFFECTIVE

RELEASED 

AUTH

DATE 





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, August 08, 2011 2:41:00 PM

Work Order ID: 72699



Parent Item: D4421-7



Parent Item Name: Lower Curve


Start Date: 8/12/2011

Required Date: 8/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.08.05 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA  304/316 .050 Sheet		Purchased	No			100	sf	234.6550	0.3817	0.803579			



13 11-8-8

Location

Loc Qty

Loc Code

MAT020

82.655

113062

13.655

116979

69

MAT021

152

118217

152

113062

3

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 72699
Description: D442 LOWER CURVE	Part Number: D4421-7
Inspection Dwg: D4421-7, Rev: PA1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

X

Prototype

[illegible]

Measured by: EB	Audited by: S	Prototype Approval:
Date: 11-8-01	Date: 11/08/01	Date:

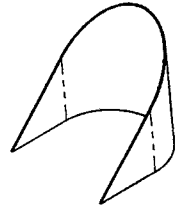
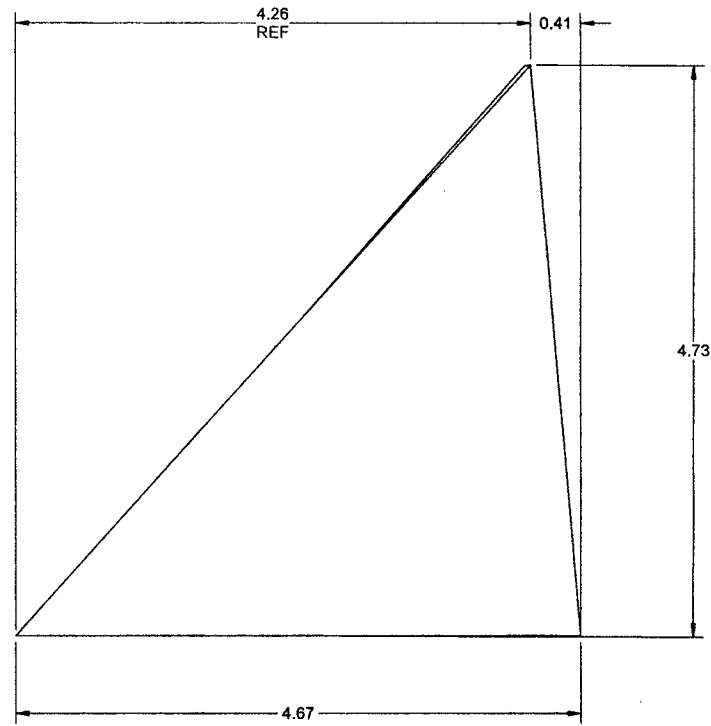
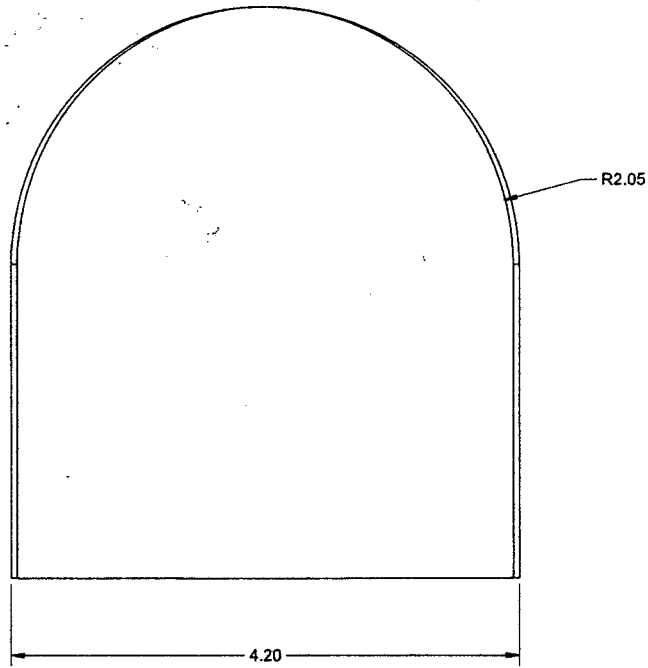
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY

RETURN TO

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71699

11-05-8



D4421-7 LOWER CURVE

PRELIMINARY ISSUE
11.07.26

- NOTES:
- 1) MATERIAL: MADE FROM D4421-7F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.46 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4421	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		HARNES COVER NTS	
DATE	11.07.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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